

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009849**Date Inspected:** 12-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF on closed U-Rib for below segments and readings forwarded to OBG SMR for further action.

5BE-5CE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (5AW-5BW)**SMAW Process:**

Welding of weld joint -002 located on PCMK OBW5A. Welder is identified as 048659.

ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-CWR8043.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW Process:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Welding of weld joint –002 located on PCMK OBW5A. Welder is identified as 049769.

ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-CWR8043.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint –001 located on PCMK OBW5. Welder is identified as 048659.

ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-CWR8040.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) –FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (5CE)

FCAW Process:

Welding of weld joint for the longitudinal diaphragm located on PCMK LD15E. Welder is identified as 220066.

ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-WR8063.

The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

OBG # TRIAL ASSEMBLY YARD (5BE)

FCAW Process:

Welding of weld joint for the longitudinal diaphragm located on PCMK LD17K. Welder is identified as 220069.

ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-WR8106.

The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4C-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
